



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200
Fax 613 632-5246

RBW2905G00132-3G

Job Sheet 192469



Part No: RBW2905G00132-3G

Job Qty: 2 pcs

Part Name: PCM Adapters, Hydraulic System Test Bench



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 3/26/19

Job Tracking No:

Due Date: 4/19/19

Created By: Marie Lajeunesse

Type: Stock

Description: S10P

Note: URF 18-766 DWG RBW2905G00132-3G REV 2 IPP REV A 18.02.15 NEW ISSUE FK VERIFY DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Small Fab - 1	2 pcs	4/19/19	4/19/19	0.00	1.00	Small Fab - 1		MLL
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
110	Small Fab - 2 - B4B	2 pcs	4/19/19	4/19/19	0.00	1.00	Small Fab - 1 - B4B		MLL
							Small Fab - 2 - B4B		
							Small Fab - 3 - B4B		
							Small Fab - 4 - B4B		
							Small Fab - 5 - B4B		
							Small Fab - 6 - B4B		
							Small Fab - 7 - B4B		
120	QC 4	2 pcs	4/19/19	4/19/19	0.00	0.00	QC 4 - 28		DAS JUN 17 2019 9-89
							QC 4 - 58		
							QC 4 - 69		
							QC 4 - 9		
							QC 4 - 46		
130	Packaging 3-1 - Stock - B4B	2 pcs	4/19/19	4/19/19	0.00	0.00	Packaging 3 - 1 - B4B		DAS JUN 17 2019 9-89
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		
							Packaging 3 - 4 - B4B		
							Packaging 3 - 5 - B4B		
							Packaging 3 - 6 - B4B		
							Packaging 3 - 7 - B4B		
							Packaging 3 - 8 - B4B		
							Packaging 3 - 9 - B4B		
							Packaging 3 - 10 - B4B		
							Packaging 3 - 11 - B4B		
							Packaging 3 - 12 - B4B		



Container No: S189596



Part: RBW2905G00132 - 3G

Job No: 192469

Serial No/Batch: S189596

Revision: 2

Inspector:

Exp Date:

Instructions:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
CANADA
TEL: 1 613 632-5200
Email: sales@dartaero.com
www.dartaerospace.com

Date: 06/12/19

Plex 3/26/19 10:58 AM Dart.lajeunesse.marie

					Packaging 3 - 13 - B4B	
					Packaging 3 - 14 - B4B	
					Packaging 3 - 15 - B4B	
					Packaging 3 - 16 - B4B	
					Packaging 3 - 17 - B4B	
					Packaging 3 - 18 - B4B	
					Packaging 3 - 19 - B4B	
					Packaging 3 - 20 - B4B	
					Packaging 3 - 21 - B4B	
					Packaging 3 - 22 - B4B	
					Packaging 3 - 23 - B4B	
					Packaging 3 - 24 - B4B	
					Packaging 3 - 25 - B4B	
					Packaging 3 - 26 - B4B	
					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
140 QC 21 - FG	2 pcs	4/19/19	0.00 0.00		QC 21 - FG - 21	DAS
					QC 21 - FG - 70	21 JUN 13 2019
					QC 21 - FG - 53	3-55

GA
15/F

Part Op 110 - 1-Engrave placard RB41011 using marktronic engraver 2-Transfer drill Dart placard RB41011 into Pelican case
 Descriptions: APP-1470-E 3-Debur holes and remove chips from case. 4-Rivet Dart placard to Pelican case 5-Glue placard
 RBW2905G00132-3G-9 to RBW2905G00132-3G-7 foam as per DWG. 6-Glue foam to case and pack case as per DWG.
 120 - (QC4- 100% Inspect kits for completeness)
 130 - (Identify as per dwg & Stock Location: _____)
 140 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RB41011	Dart Tooling Placard, Aluminum	2 Ea (1 ea)	90-Small Fab - 1	5021040
97524A032	Sealing Blind Rivet	8 Ea (4 ea)	110-Small Fab - 2 - B4B	5145165
APP-1470-E	Case	2 Ea (1 ea)	110-Small Fab - 2 - B4B	5175852
RBW2905G00132-3G-5	Bottom Foam use in case APP-1470-E	2 Ea (1 ea)	110-Small Fab - 2 - B4B	5175850
RBW2905G00132-3G-7	Top Foam use in case APP-1470-E	2 Ea (1 ea)	110-Small Fab - 2 - B4B	5175851
RBW2905G00132-3G-9	Plastic Placard	2 pcs (1 ea)	110-Small Fab - 2 - B4B	5124126
RBW2905G00232-3G	Adapter Assembly, Pcm Return Line	4 pcs (2 ea)	110-Small Fab - 2 - B4B	5188974
RBW2905G00332-3G	Adapter Assembly, Pcm Pressure Line	4 pcs (2 ea)	110-Small Fab - 2 - B4B	5155506

128A-B
151F97
106
107

010320

Job Allocations

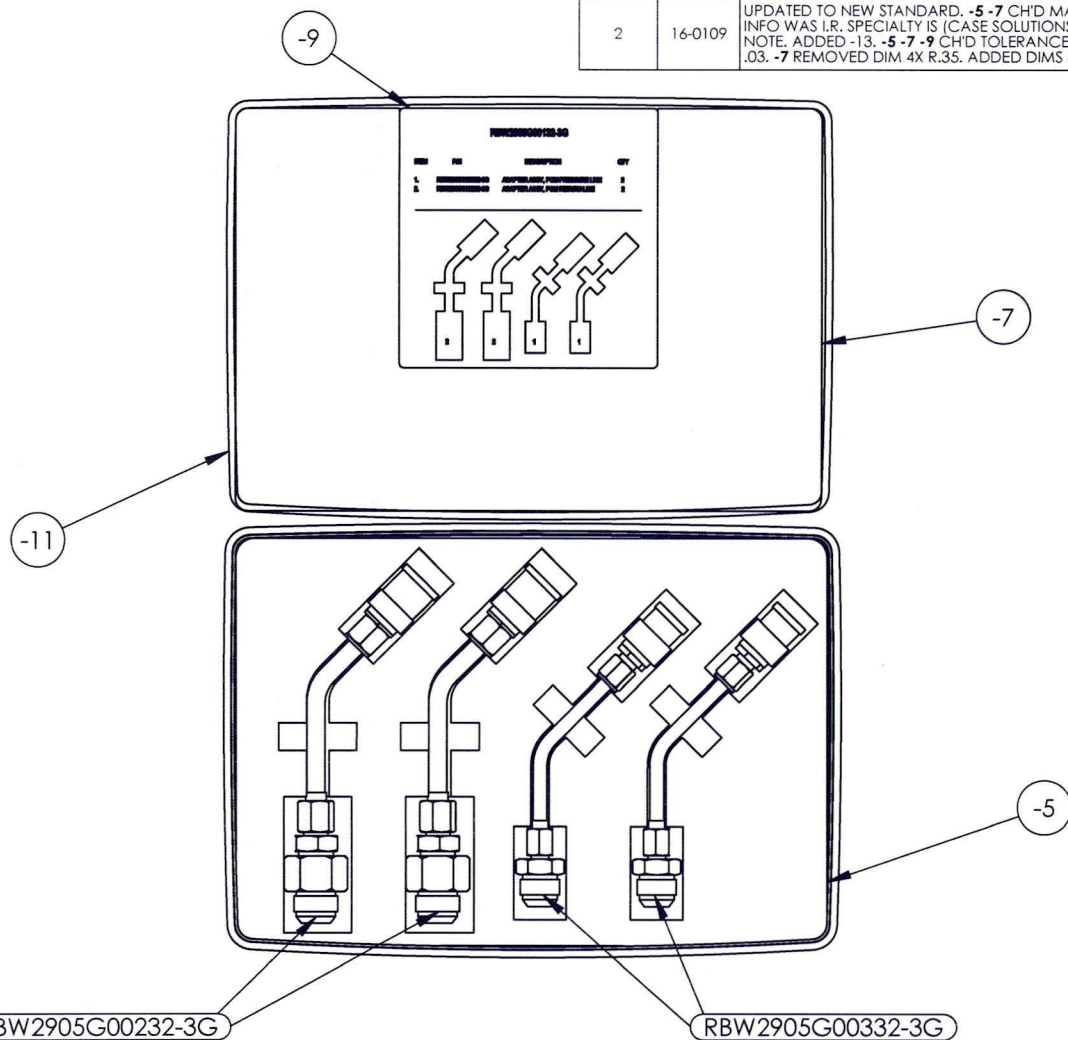
Operation	Component Part	Required	Inventory	Allocated
90-Small Fab - 1	RB41011	2	369	0
110-Small Fab - 2 - B4B	97524A032	8	401	0
	APP-1470-E	2	7	0
	RBW2905G00132-3G-5	2	4	0
	RBW2905G00132-3G-7	2	4	0
	RBW2905G00132-3G-9	2	4	0
	RBW2905G00232-3G	4	2	0
	RBW2905G00332-3G	4	4	0

Part Specifications

Specifications could not be found.

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		INCREASED FITTING CUTOUTS, FROM 2.69 TO 3.09 - FROM 3.43 TO 3.68 - FROM 2.71 TO 3.01 - FROM 2.23 TO 2.53.	5/23/2011	JAG	
2	16-0109	UPDATED TO NEW STANDARD. -5 -7 CH'D MAT'L WAS Y20 BLACK IS ETHAFOAM 220 BLACK. CH'D B/O INFO WAS I.R. SPECIALTY IS (CASE SOLUTIONS). -9 CH'D MAT'L WAS ALUMINUM IS PLASTIC. ADDED NOTE, ADDED -13. -5 -7 -9 CH'D TOLERANCES WAS .XXX ± .005 IS .XXX ± .010, WAS .XX ± .01 IS .XX ± .03. -7 REMOVED DIM 4X R.35. ADDED DIMS 4X .66, 4X 36°.	8/11/2016	DEW	JAG



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 192469 MLS
1903-26

NOTE:
REF. AGUSTA T/N: 3G2905G00132.

DART AEROSPACE																					
TITLE PCM ADAPTERS KIT, HYDRAULIC SYSTEM TEST BENCH																					
DWG NO. RBW2905G00132-3G	REV 2																				
<table border="1"> <tr> <td>MAT'L</td> <td>UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES</td> </tr> <tr> <td>FEAT</td> <td>.XXX ± .005 FRACTIONS ± 1/8</td> </tr> <tr> <td>TREAT</td> <td>.XX ± .01 ANGLES ± 5°</td> </tr> <tr> <td>FINISH</td> <td>.X ± .1 SURFACES = 125/</td> </tr> <tr> <td>SPEC</td> <td>1. BREAK ALL SHARP EDGES .015 x 45° OR .015R</td> </tr> <tr> <td>DRAWN BY: GILBERT</td> <td>2. DIMENSIONAL LIMITS APPLY AFTER PLATING</td> </tr> <tr> <td>CHECKED: DUERFELDT</td> <td>3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009</td> </tr> <tr> <td>OPPS APPR: ANDERSON</td> <td>USED ON MODEL</td> </tr> <tr> <td>QA APPR: LINDSAY</td> <td>AUGUSTA AW139</td> </tr> <tr> <td>APPROVED: GILBERT</td> <td></td> </tr> </table>		MAT'L	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES	FEAT	.XXX ± .005 FRACTIONS ± 1/8	TREAT	.XX ± .01 ANGLES ± 5°	FINISH	.X ± .1 SURFACES = 125/	SPEC	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R	DRAWN BY: GILBERT	2. DIMENSIONAL LIMITS APPLY AFTER PLATING	CHECKED: DUERFELDT	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009	OPPS APPR: ANDERSON	USED ON MODEL	QA APPR: LINDSAY	AUGUSTA AW139	APPROVED: GILBERT	
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APPROVED: GILBERT																					
SCALE 1:5	DATE 3/4/2011 SHEET 1 OF 4																				

ASSY QTY	ASSY QTY	B/O	Part #	QTY.	Description	Material	B/O INFORMATION OR SPECIFICATIONS	PG.
				2	ADAPTER ASSY, PCM RETURN LINE		RBW2905G00232-3G	1
				2	ADAPTER ASSY, PCM PRESSURE LINE		RBW2905G00332-3G	1
		B/O	-5	1	BOTTOM TOOL CUSHION	ETHAFOAM 220, BLACK	16.0 X 11.0 X 2.3 (CASE SOLUTIONS)	2
		B/O	-7	1	TOP TOOL CUSHION	ETHAFOAM 220, BLACK	15.85 X 10.85 X 1.58 (CASE SOLUTIONS)	3
			-9	1	PLACARD	PLASTIC		4
		B/O	-11	1	CASE	PLASTIC	PELICAN #APP-1470-E	1
		B/O		1	DART PLACARD	ALUMINUM	RB41011	

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation			Disposition		
			Completed By		
			Lead hand / Supervisor Approval Verification		
			QC / QA Coordinator Approval		
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
Misidentified ☐	Past Due ☐				